

Date: Wednesday, 11/06/2008 9:13:58 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	205 SKIDTUBE "I" BEAM
Job Number :	39769		
Estimate Number :	10346		
P.O. Number :		Part Number :	D2596
This Issue :	11/06/2008	Drawing Number :	D2596 REV D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	10/06/2008	Drawing Revision :	D
Previous Run :	39538	Material :	
Written By :		Due Date :	17/06/2008
Checked & Approved By :	JUL 08.6.11		
Comment :	Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM		

Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n -I' Beam Web 4"
-----	-----------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Extrusion "I" Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	B33940 D M 8-6-11

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------

**Comment:** LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

) K 8-6-11 (6)

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid Etch and Alodine per QSI 005 4.1

(6) M 8-6-11

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

508/06/11 (46)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 39769

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6.

⑥

N 8-6-11

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/12 *[Signature]*

Job Completion



MF 08-06-12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

HAWKESBURY, ONTARIO, CANADA

REV. D

DRAWING NO.

06C7D

SHEET 1 OF 1

205 WEB

1:20

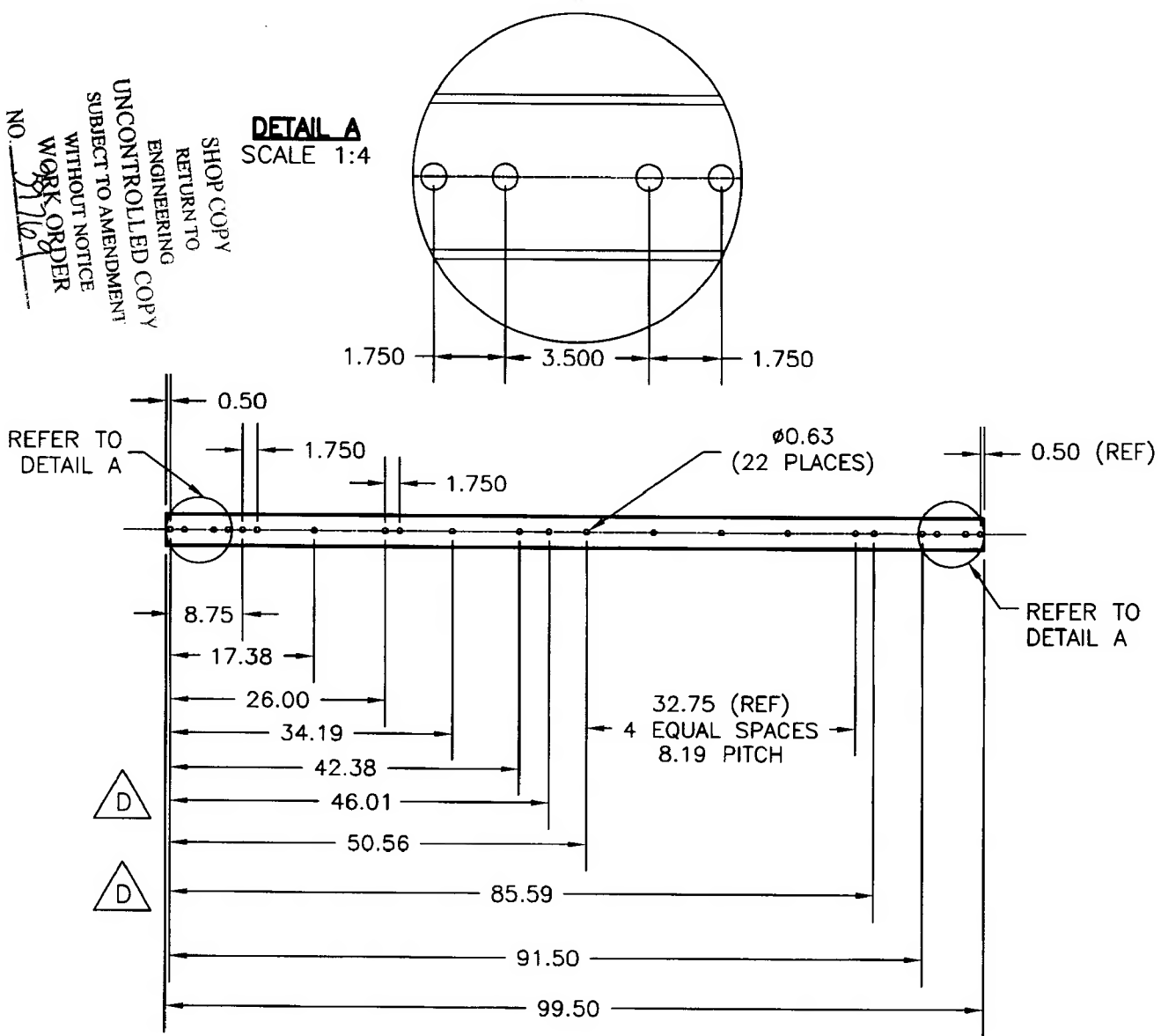
NEW ISSUE

Ø0.63

INCORPO

INCORPORATE

RELEASED
07 Dec 68



DETAIL A
SCALE 1:4

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2716

D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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Dart Aerospace Ltd

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